

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch

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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 1.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-022416**Date Inspected:** 31-Mar-2011**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1530**Contractor:** American Bridge/Fluor Enterprises, a JV**Location:** Job Site**CWI Name:** Steve McConnell**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** Tower Grillage**Summary of Items Observed:**

This Quality Assurance (QA) Inspector, Craig Hager was on site at the job site between the times noted above.

This QA Inspector was on site to randomly observe Quality Control (QC) personnel perform Non-Destructive Testing (NDT) and monitor American Bridge/Fluor (ABF) welding operations. This Quality Assurance (QA) Inspector, Craig Hager randomly observed the following.

North and South Suspender Brackets:

Production welding is completed, QC inspections are completed and accepted, QA verification inspections completed.

East Tower leg:

Production welding is completed, QC inspections are completed and accepted, QA verification inspections completed.

South Tower leg:

Production welding is completed, QC inspections are completed and accepted, QA verification inspections completed.

West Tower leg:

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## WELDING INSPECTION REPORT

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Production welding is completed, QC inspections are completed and accepted, QA verification inspections completed.

North Tower leg:

This QA Inspector was present to observe the final testing (after 48 hours) of repaired welds TG-N-P1-P2 and TG-N-P5-P7. At approximately 0830 hours this date QC Supervisor Bill Norris informed this QA Inspector that QC Inspector Mike Johnson would be present at 1415 to perform the Ultrasonic Testing (UT) on the repair welds noted above. At 1430 hours this QA Inspector and Construction Engineer Soman Soheili had been present and waiting for QC Inspector Mike Johnson. This QA Inspector called QC Inspector Mike Johnson via phone and was informed he would be available in a few minutes. At approximately 1445 QC Inspector Mike Johnson arrived to perform the UT. This QA Inspector randomly observed as he performed the UT and performed verification UT after QC Inspector Mike Johnson informed both this QA Inspector and Construction Engineer Soman Soheili the final inspection was completed and accepted. This appeared to have completed the required testing after the 48 hour waiting period. The work observed appeared to be in accordance with the contract requirements.

### Summary of Conversations:

This QA Inspector had general conversations with American Bridge/Fluor (ABF) and Caltrans personnel during this shift. Except as described above there were no notable conversations.

### Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Nina Choy (510) 385-5910, who represents the Office of Structural Materials for your project.

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<b>Inspected By:</b>	Hager,Craig	Quality Assurance Inspector
<b>Reviewed By:</b>	Levell,Bill	QA Reviewer

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